

**DEPARTMENT OF TRANSPORTATION**

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch  
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 99.28**WELDING INSPECTION REPORT****Resident Engineer:**Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-013396**Date Inspected:** 04-Apr-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC) Chanxing Island**Location:** Shanghai, China

|                                    |              |           |            |
|------------------------------------|--------------|-----------|------------|
| <b>CWI Name:</b>                   | Mr. Geng Wei |           |            |
| <b>Inspected CWI report:</b>       | <b>Yes</b>   | <b>No</b> | <b>N/A</b> |
| <b>Electrode to specification:</b> | <b>Yes</b>   | <b>No</b> | <b>N/A</b> |
| <b>Qualified Welders:</b>          | <b>Yes</b>   | <b>No</b> | <b>N/A</b> |
| <b>Approved Drawings:</b>          | <b>Yes</b>   | <b>No</b> | <b>N/A</b> |

|                                  |            |           |            |
|----------------------------------|------------|-----------|------------|
| <b>CWI Present:</b>              | <b>Yes</b> | <b>No</b> |            |
| <b>Rod Oven in Use:</b>          | <b>Yes</b> | <b>No</b> | <b>N/A</b> |
| <b>Weld Procedures Followed:</b> | <b>Yes</b> | <b>No</b> | <b>N/A</b> |
| <b>Verified Joint Fit-up:</b>    | <b>Yes</b> | <b>No</b> | <b>N/A</b> |
| <b>Approved WPS:</b>             | <b>Yes</b> | <b>No</b> | <b>N/A</b> |
| <b>Delayed / Cancelled:</b>      | <b>Yes</b> | <b>No</b> | <b>N/A</b> |

**Bridge No:** 34-0006**Component:** OBG Segment**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance Inspector (QA), Vibin Kumar Selvanayaham, was present during the times noted above for observations relative to the work being performed.

Bay 14

This QA inspector observed ZPMC qualified welding personnel identified as 058551 perform Flux Cored Arc Welding (FCAW) Welding on OBG Segment 12AE, weld joint identified as SEG3001T-020 and 027. ZPMC QC is identified as Mr. Zhong Guo Hui. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS-B-T-2233-Tc-U4b-F.

This QA inspector observed ZPMC qualified welding personnel identified as 055564 perform FCAW Welding on OBG Segment 12AE, weld joint identified as SEG3001T-049 and 050. ZPMC QC is identified as Mr. Zhong Guo Hui. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS-B-T-2232-Tc-U4b-F.

This QA inspector observed ZPMC qualified welding personnel identified as 044801 perform FCAW Welding on OBG Segment 12AE, weld joint identified as SEG3001T-045 and 046. ZPMC QC is identified as Mr. Zhong Guo Hui. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS-B-T-2232-Tc-U4b-F.

This QA inspector observed ZPMC qualified welding personnel identified as 050242 perform FCAW Welding on

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OBG Segment 12AE, weld joint identified as SEG3001X-049 and 050. ZPMC QC is identified as Mr. Zhong Guo Hui. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS-B-T-2232-Tc-U4b-F.

This QA inspector observed ZPMC qualified welding personnel identified as 044795 perform FCAW Welding on OBG Segment 12AE, weld joint identified as SEG3001T-045 and 046. ZPMC QC is identified as Mr. Zhong Guo Hui. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS-B-T-2232-Tc-U4b-F.

This QA inspector observed ZPMC qualified welding personnel identified as 200113 perform Shielded Metal Arc Welding (SMAW) Welding on OBG Segment 12AE, weld joint identified as SEG3001T-010 and 011. ZPMC QC is identified as Mr. Zhong Guo Hui. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS-B-P-2214-Tc-U4b-FCM-1.

This QA inspector observed ZPMC qualified welding personnel identified as 048038 perform FCAW Welding on OBG Segment 12CE, weld joint identified as DP3030-001-066, 067, 086 and 087. ZPMC QC is identified as Mr. Wang Xu. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS-B-T-2133.

This QA inspector observed ZPMC qualified welding personnel identified as 214945 perform FCAW Welding on OBG Segment 12CE, weld joint identified as DP3030-001-106, 107, 014 and 015. ZPMC QC is identified as Mr. Wang Xu. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS-B-T-2133.

This QA inspector observed ZPMC qualified welding personnel identified as 048038 perform FCAW Welding on OBG Segment 12CE, weld joint identified as DP3030-001-135, 136, 145, 146, 063, 064, 073, and 074. ZPMC QC is identified as Mr. Wang Xu. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS-B-T-2132.

This QA inspector observed ZPMC qualified welding personnel identified as 214945 perform FCAW Welding on OBG Segment 12CE, weld joint identified as DP3030-001-103, 104, 113, 114, 011, 012, 021 and 022. ZPMC QC is identified as Mr. Wang Xu. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS-B-T-2132.

This QA inspector observed ZPMC qualified welding personnel identified as 055491 and 052096 perform FCAW Welding on OBG Segment 12BE, weld joint identified as CA3003C-003. ZPMC QC is identified as Mr. Guo Xing Hui. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS-B-T-2233-Tc-U4b-F.

This QA inspector observed ZPMC qualified welding personnel identified as 066733 perform FCAW Welding on OBG Segment 12BE, weld joint identified as CA3003C-113~124. ZPMC QC is identified as Mr. Guo Xing Hui. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS-B-T-2132.

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This QA inspector observed ZPMC qualified welding personnel identified as 055491 perform FCAW Welding on OBG Segment 12BE, weld joint identified as CA3003C-051~062. ZPMC QC is identified as Mr. Guo Xing Hui. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS-B-T-2132.

This QA inspector observed ZPMC qualified welding personnel identified as 055491 perform FCAW Welding on OBG Segment 12BE, weld joint identified as CA3003D-051~062. ZPMC QC is identified as Mr. Guo Xing Hui. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS-B-T-2132.

This QA inspector observed ZPMC qualified welding personnel identified as 052696 perform FCAW Welding on OBG Segment 12BE, weld joint identified as CA3003C-041~050. ZPMC QC is identified as Mr. Guo Xing Hui. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS-B-T-2133.

This QA inspector observed ZPMC qualified welding personnel identified as 052696 perform FCAW Welding on OBG Segment 12BE, weld joint identified as CA3003D-041~050. ZPMC QC is identified as Mr. Guo Xing Hui. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS-B-T-2133.

This QA observed ZPMC personnel performing MT Inspection on OBG Segment 12BE deck panel to longitudinal diaphragm CJP and Fillet joints. The deck panel is identified as DP3021A. See the attached picture.

Visual Inspection after Blast

OBG Segment 9BW

This QA Inspector performed a preliminary random visual inspection after the grit blast of the interior components of the deck panel, floor beams and corner assemblies of this segment. Areas of visual weld defects that will require welding were taped and will be repaired after the coating is applied. ZPMC QC personnel are aware of these areas and were present during the inspection. See the attached picture.

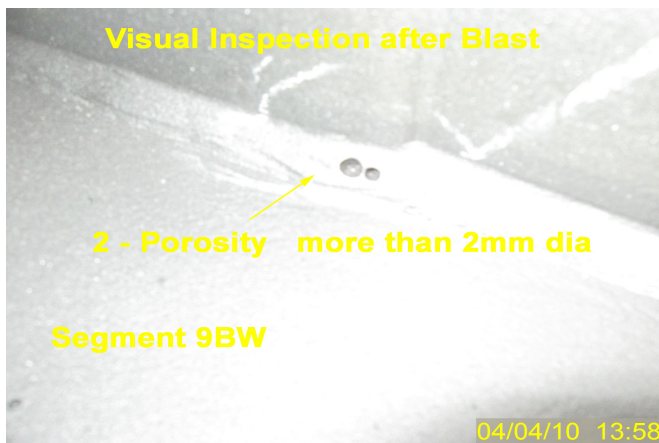
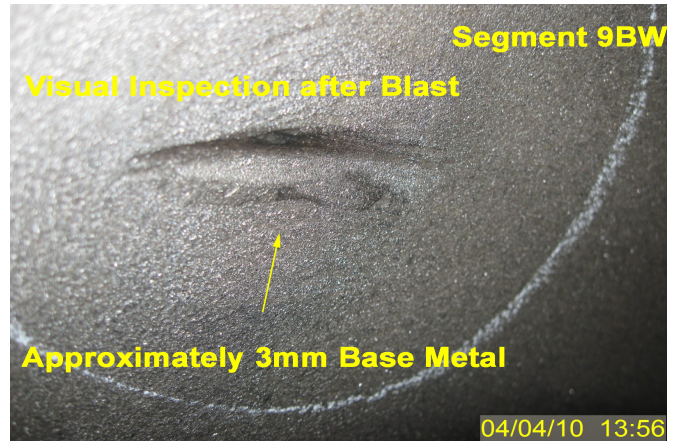
Unless otherwise noted, all work observed on this date appeared to be in general compliance with the applicable contract documents.

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## Summary of Conversations:

Only general conversation was held between QA and QC concerning this project.

## Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact , who represents the Office of Structural Materials for your project.

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**Inspected By:** Kumar,Vibin

Quality Assurance Inspector

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**Reviewed By:** McClendon,Timothy

QA Reviewer

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